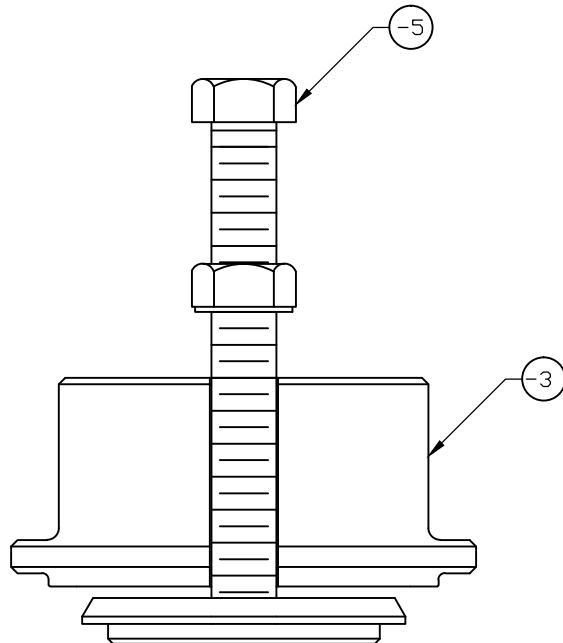


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		REVISIONS		
REV	DESCRIPTION	DATE	INITIAL	APPROVED

SEE ATTACHED DEVIATION



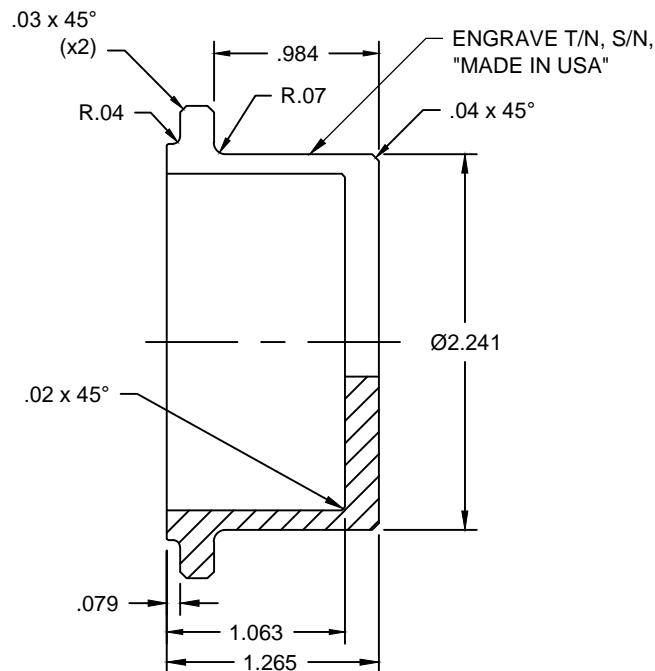
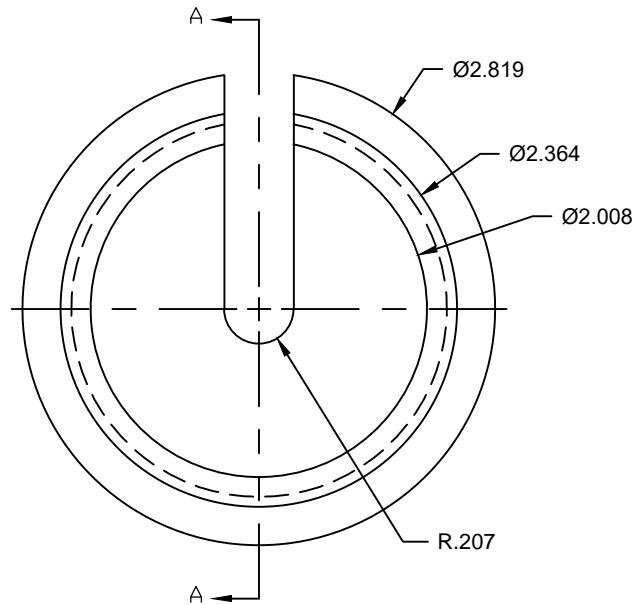
ASSY QTY	ASSY QTY	B/O	PART #	UNIT QTY	DESCRIPTION	MATERIAL	B/O INFORMATION OR SPECIFICATIONS	Pg.
			-3	1	CUP	4140 Q&T	Ø3 x 1-1/2	2
X			-5	1	INSTALLER ASSEMBLY			3
1			-7		INSTALLER	4140 Q&T	Ø2 x 7/16	4
1	B/O	-9			HEX HEAD CAP SCREW FULL THREAD	STEEL	M10 x 1.25 x 80mm REID #ROC-2802-749	3
1	B/O	-11			HEX NUT	STEEL	M10 x 1.25 REID #ROC-2804-703	3
ASSY -5								

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON: DECIMALS .XXX ± .005 .XX ± .01 .X ± .1	DRAWN BY:	CLOUGH
	APPROVED	D Weil
FRACTIONS ± 1/32 ANGLES ± 5°	HEAT TREAT	
SPEC	FINISH	
	USED ON MODEL	
	EC145	
SCALE	NTS	DATE 7-14-10 SHEET 1 of 4

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SECTION A-A

(-3)

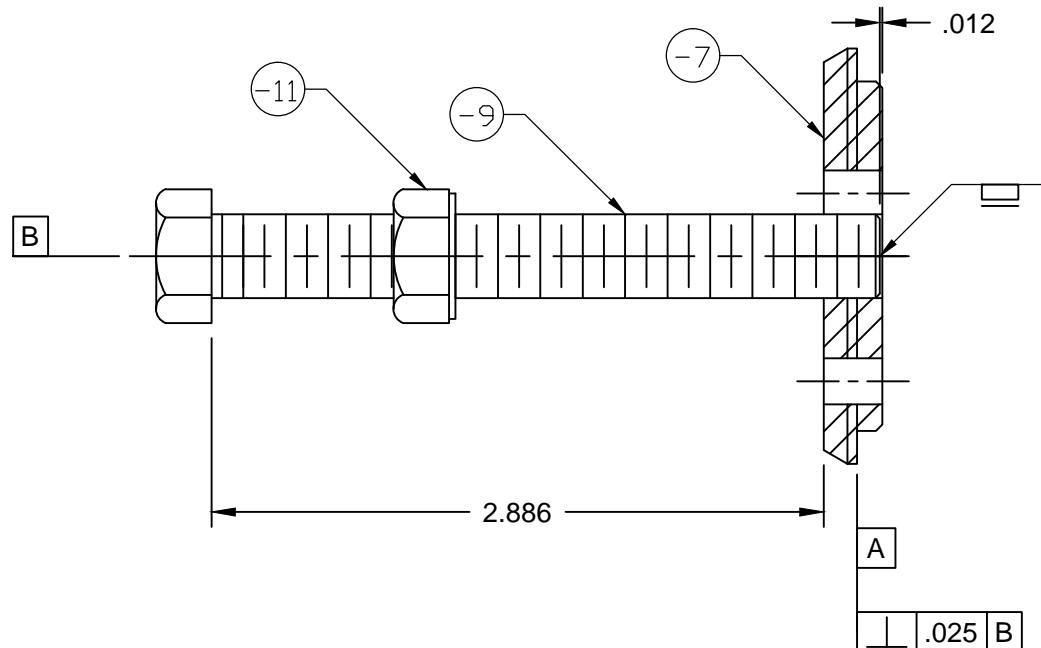
CUP

RED BARN MACHINE	
TITLE PUSHER MGB INPUT SEAL	
DWG NO. RBE117-12020-W20-3	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5°	
DRAWN BY: CLOUGH APPROVED <i>D. Weil</i>	
HEAT TREAT	
FINISH BLACK OXIDE	
SPEC	
USED ON MODEL	
EC145	
SCALE NTS	DATE 7-14-10
SHEET 2 of 4	

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REV		DESCRIPTION		DATE	INITIAL	APPROVED

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INSTALLER ASSEMBLY

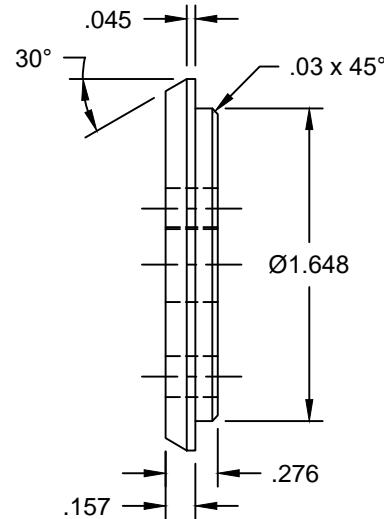
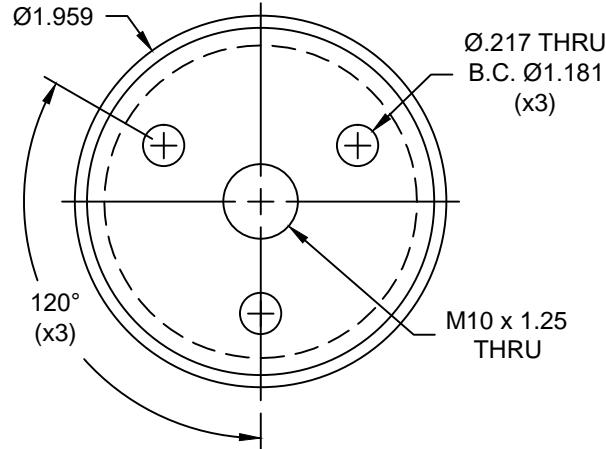
(-5)

RED BARN MACHINE	
TITLE PUSHER MGB INPUT SEAL	
DWG NO. RBE117-12020-W20-5	REV
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5°	
DRAWN BY: CLOUGH APPROVED <i>D. Weil</i>	
HEAT TREAT	
FINISH BLACK OXIDE	
SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R. 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	
EC145	
SCALE NTS	DATE 7-14-10
SHEET 3 of 4	

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REV		REVISIONS	
		DESCRIPTION	DATE
		INITIAL	APPROVED

SEE ATTACHED DEVIATION



(-7)
INSTALLER

RED BARN MACHINE	
TITLE PUSHER MGB INPUT SEAL	
DWG NO. RBE117-12020-W20-7 REV	
UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	
TOLERANCES ON: DECIMALS .XXX ± .005 FRACTIONS ± 1/32 .XX ± .01 ANGLES ± .5°	
HEAT TREAT FINISH SEE WELDMENT	
SPEC	
UNLESS OTHERWISE SPECIFIED 1. BREAK ALL SHARP EDGES .015 x 45° PR. .015 R. 2. DIMENSIONAL LIMITS APPLY AFTER PLATING	
USED ON MODEL	EC145
SCALE NTS	DATE 7-14-10
SHEET 4 of 4	

Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

Route update only

Job: _____ Part No. RBE117-12020-W20 REV. N/A		DISPOSITION		DEPARTMENT/PROCESS					
		Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/>	Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Large Fab <input type="checkbox"/>	Cross tube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/>	Eng. (Non-AW) <input checked="" type="checkbox"/> Prod. Eng. Coor. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/>	Engineering <input type="checkbox"/> Water Jet <input type="checkbox"/> Supplier Quality <input type="checkbox"/>			
Date : _____	Sequence #: _____	QTY Affected : _____				MRB (QSI042) <i>M. Lee</i> JAN 29, 2019			
Description Work Order Deviation			Disposition						
RBE117-12020-W20-9 USE OF HARDWARE McMaster#93000A618 (FULL THREADED ROD M10 X 1.25) WITH #ROC-2804-703 (HEX NUT M10 X 1.25) WELDED AT APPROPRIATE LENGTH IS ACCEPTABLE. FULL THREADED ROD & HEX NUT ZINC-PLATING MUST BE REMOVED PRIOR BLACK OXIDE FINISH.			THIS DEVIATION IS ACCEPTABLE THE FIT, FORM, AND FUNCTION OF THE PART WILL BE AS ORIGINALLY INTENDED						
			Completed By Lead hand / Supervisor QC / QA Coordinator						
PER MBB									
Root Cause		FAULT CATEGORY							
Operator <input type="checkbox"/>	Manufacturing Process <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>	Contamination <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>				
Equip/Tooling <input type="checkbox"/>	Handling/Preservation <input type="checkbox"/>	Bending <input type="checkbox"/>	Misaligned/off center <input type="checkbox"/>	Folio/Program <input type="checkbox"/>	Outside Tolerance <input type="checkbox"/>				
Material <input type="checkbox"/>	Product Improvement <input checked="" type="checkbox"/>	Crushing <input type="checkbox"/>	BOM/Route <input type="checkbox"/>	Grain Direction <input type="checkbox"/>	Drawing <input type="checkbox"/>				
	Process Improvement <input type="checkbox"/>	Cracks <input type="checkbox"/>	Broken/Damage/Defect <input type="checkbox"/>	Weld <input type="checkbox"/>	Finish <input type="checkbox"/>				
Human Factors <input type="checkbox"/>		Crimp/Kink/Ripple/Wave/Twist <input type="checkbox"/>	Incomplete/Unclear Instructions <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>				
		Marks/Chatter <input type="checkbox"/>	Drill Holes <input type="checkbox"/>	Out of Sequence <input type="checkbox"/>	Misread <input type="checkbox"/>				
		Mislabeled <input type="checkbox"/>	Fit/Function <input type="checkbox"/>	Off-set/Set-up <input type="checkbox"/>					
Other/Details: BOLT RBE117-12020-W20-9 (P/N ROC-2802-749) IS NOT FULLY THREADED									